

Date: Wednesday, 15/04/2009 3:16:43 PM
 User: Melanie Fauteux

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	SEAT BELT REEL BRACKET ASS'Y
Job Number :	47234		
Estimate Number :	13854		
P.O. Number :		Part Number :	D3925041
This Issue :	15/04/2009	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D3925 REVA PRELIM
First Issue :	//	Project Number :	N/A
Previous Run :	47220	Drawing Revision :	A PRELIM
Written By :		Material :	
Checked & Approved By :	<u>MF 09-04-15</u>	Due Date :	20/04/2009
Comment :	Est Rev: A New Issue 09.04.14 EC verified: DD		

09.04.24

Qty: 2 Um: Each

Additional Product

PRELIMINARY ISSUE

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6S125	6061-T6 .125 Sheet
-----	-------------	--------------------



Comment: Qty.: 0.1029 sf(s)/Unit Total : 0.2058 sf(s)
 6061-T6 aluminum sheet 0.125" thick

Batch: 11062 B 9-4-16

2.0	WATER JET <u>11062</u>	FLOW WATER JET
-----	------------------------	----------------



Comment: FLOW WATER JET
 1-Cut as per Dwg D3925
 Dwg Rev: PRE
 Prog Rev: LIM

B 9-4-16

(2)

2-Deburr if necessary B 9-4-16

*****identify as D3925-1*****

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

B 9-4-16

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

05-4-16 (2)

5.0	M6061T6S125	6061-T6 .125 Sheet
-----	-------------	--------------------



Comment: Qty.: 0.0450 sf(s)/Unit Total : 0.0900 sf(s)

6061-T6 .125 Sheet
 batch: 110062 B 9-4-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 15/04/2009 3:16:43 PM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SEAT BELT REEL BRACKET ASS'Y

Job Number: 47234

Part Number: D3925041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

WATER JET

FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3925

Dwg Rev: PDE

Prog Rev: Lim IB 9-4-16

2-Deburr if necessary

IB 9-4-16

*****identify as D3925-3*****

7.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

8.0

QC8

SECOND CHECK



Comment: SECOND CHECK

IB 9-4-16 (2)

ENGINEERING
APPROVAL
04-24

9.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Form D3925-1 and -3 as per dwg D3925

SB 09/04/22

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09-22 (2)
each

11.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M. 04/04/22

(2X)

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09/04/23 (2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 15/04/2009 3:16:43 PM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SEAT BELT REEL BRACKET ASS'Y

Job Number: 47234

Part Number: D3925041

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

MS20470AD5

Rivet



Comment: Qty.: 3.0000 Each(s)/Unit Total: 6.0000 Each(s)

Rivet

B2655

EF 09/04/23

14.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per dwg D3925

EF 09/24/23

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

ENGINEERING
APPROVAL

04.04.23 09/04/23 P10

16.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

GA

MF 09-04-24

17.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



POSITIVE RECALL

EFFECTIVE 09/04/24

RELEASED

DATE

09/04/24

MF 09-04-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		Powder coat per Dwg D3925 & QS1005 START 11:20 grey sandtex (4.3.5.6) TEMP 320° BT F TIM = 1:00		09-04-23	2		E 09-04-23
		QC3 inspect Powder coat	YJ	09-04-23	(X2)		S 09-04-23

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

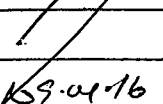
NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 47 234
Description: SEAT BELT REEL BRACKET ASS'Y		Part Number: D3925-1
Inspection Dwg: D3925-1 Rev: PRE L.M.		Page 1 of 2

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype *Preliminary*

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .157	+ .005 - .001	.159	✗			
Ø .209	+ .005 - .001	.209	✗			
1.420	+/- .010	1.421	✗			
1.600	+/- .010	1.600	*			
.533	+/- .010	.530	*			
.38	+/- .030	.381	*			
.311	+/- .010	.311	*			
3.00	+/- .030	3.003	*			
3.20	+/- .030	3.201	✗			
.400	+/- .010	.401	*			
1.41	+/- .030	1.414	*			
4.59	+/- .030	4.592	✗			
.98	+/- .030	.982	✗			
.288	+/- .010	.288	✗			
5.95	+/- .030	5.948	*			
2.25	+/- .030	2.260	✗			
.125	+/- .010	.121	*			

Measured by: IB	Audited by: 	Prototype Approval:
Date: 9-4-16	Date: 159-01-16	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

DART AEROSPACE LTD	Work Order:	47234
Description: SEAT BELT REEL ASS'y	Part Number:	D3925-3
Inspection Dwg: D3925-3 Rev: PRE Lim		Page 2 of 2

FIRST ARTICLE INSPECTION CHECKLIST


X

First Article

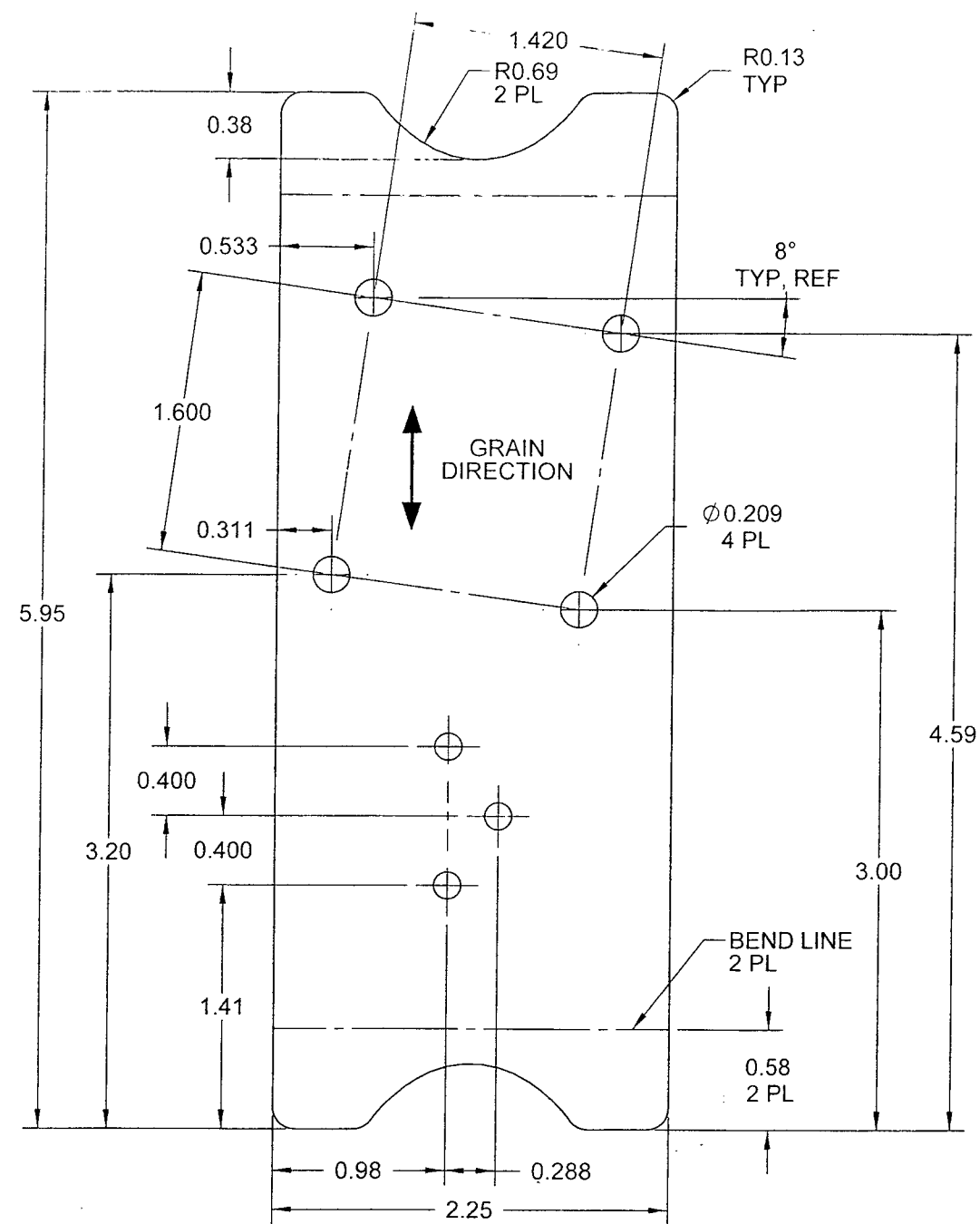
~~Prototype~~

Preliminary

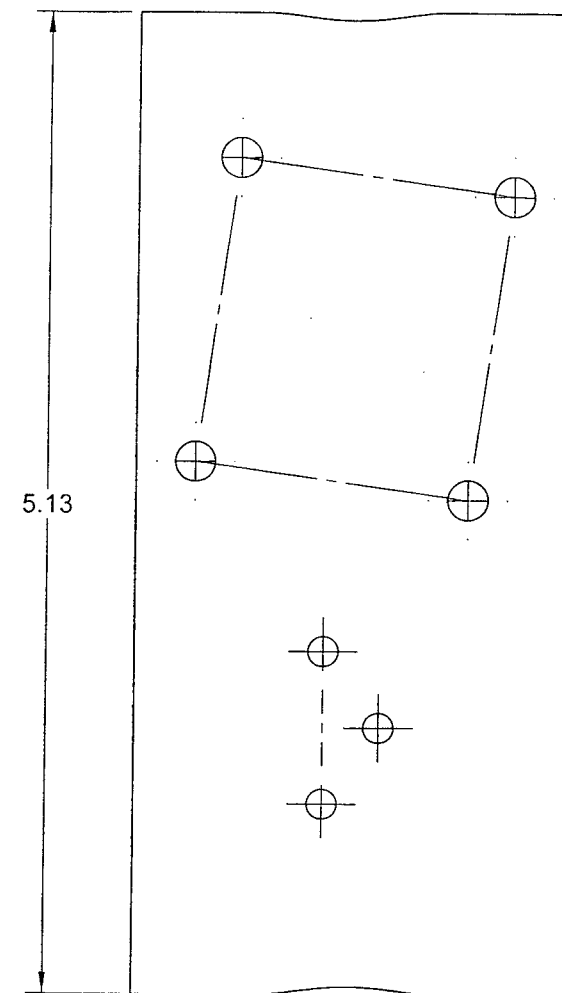
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Measured by: IB	Audited by: 	Prototype Approval:
Date: 9-4-16	Date: 15 Sep 16	Date:

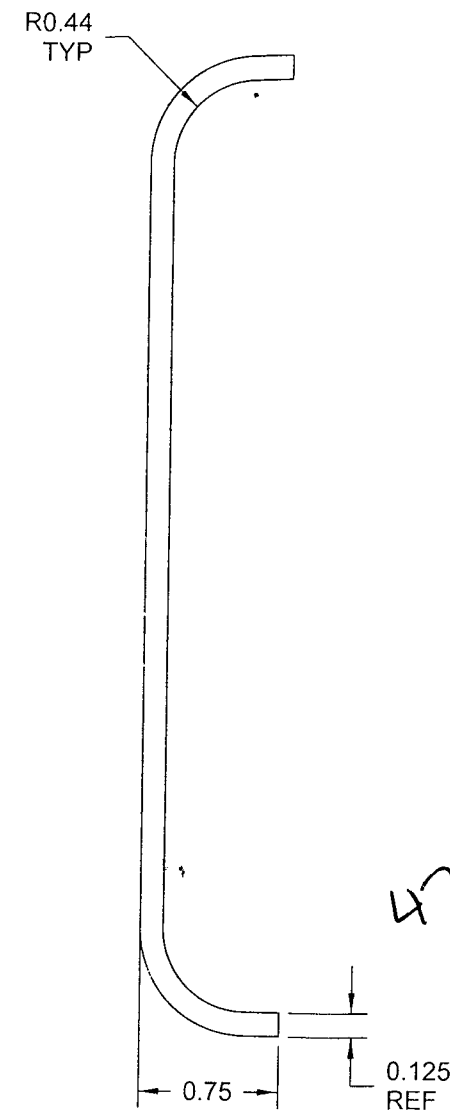
Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



D3925-1F FLAT PATTERN



D3925-1 SEATBELT REEL BRACKET
(MAKE FROM D3925-1F)



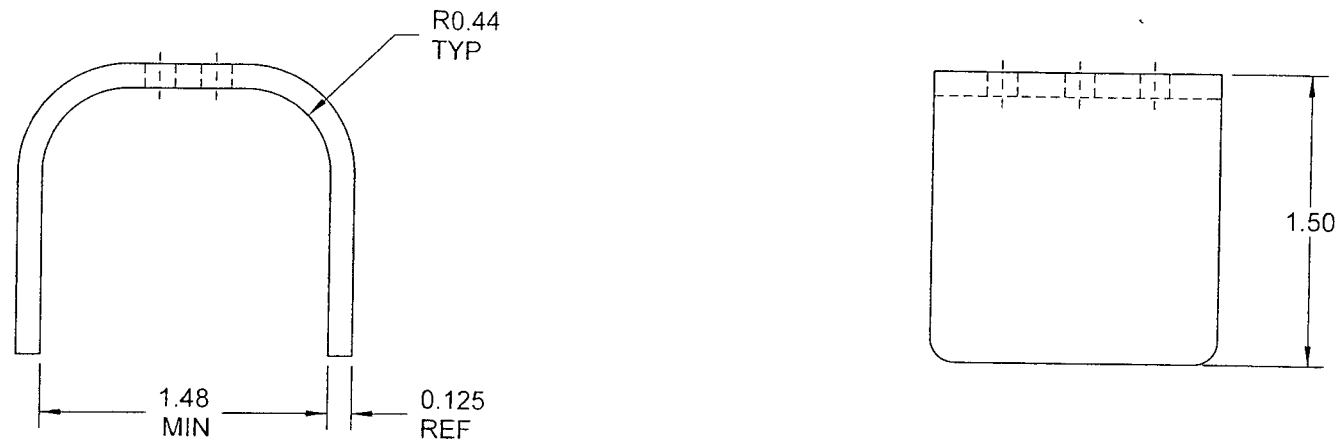
**PRELIMINARY
ISSUE**

AJS 08.04.14

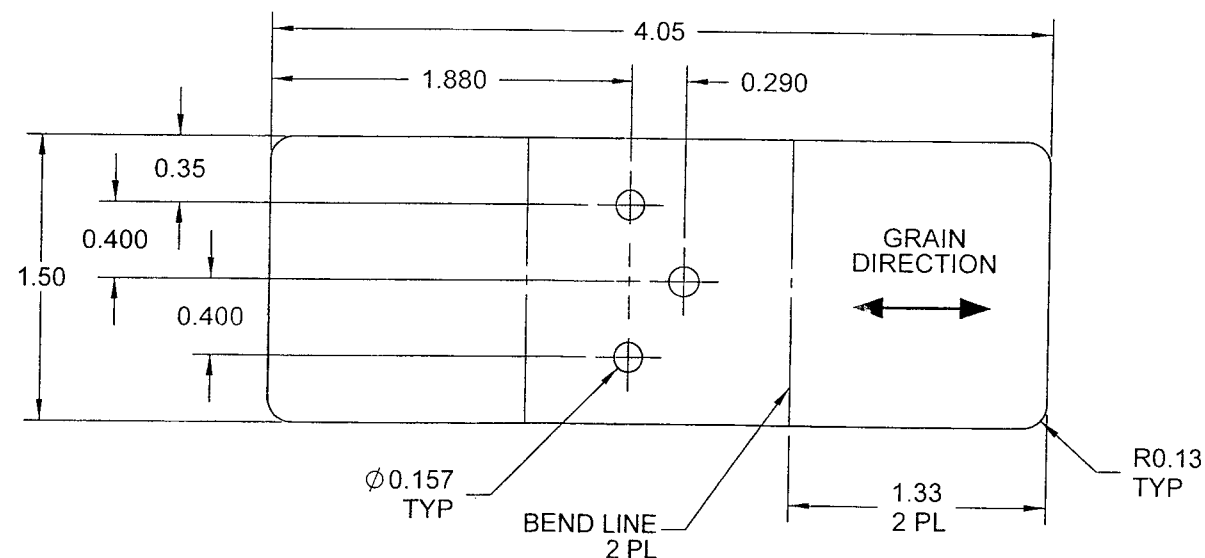
NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM 0.125 THICK PER AMS-QQ-A-250/11 OR AMS 4025/4027
REF DART SPEC M6061T6S.125
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.15 lbs

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D3925	SHEET 3 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.		SEATBELT REEL BRACKET ASSY	NTS
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D3925-3 SEATBELT REEL BRACKET
(MAKE FROM D3925-3F)

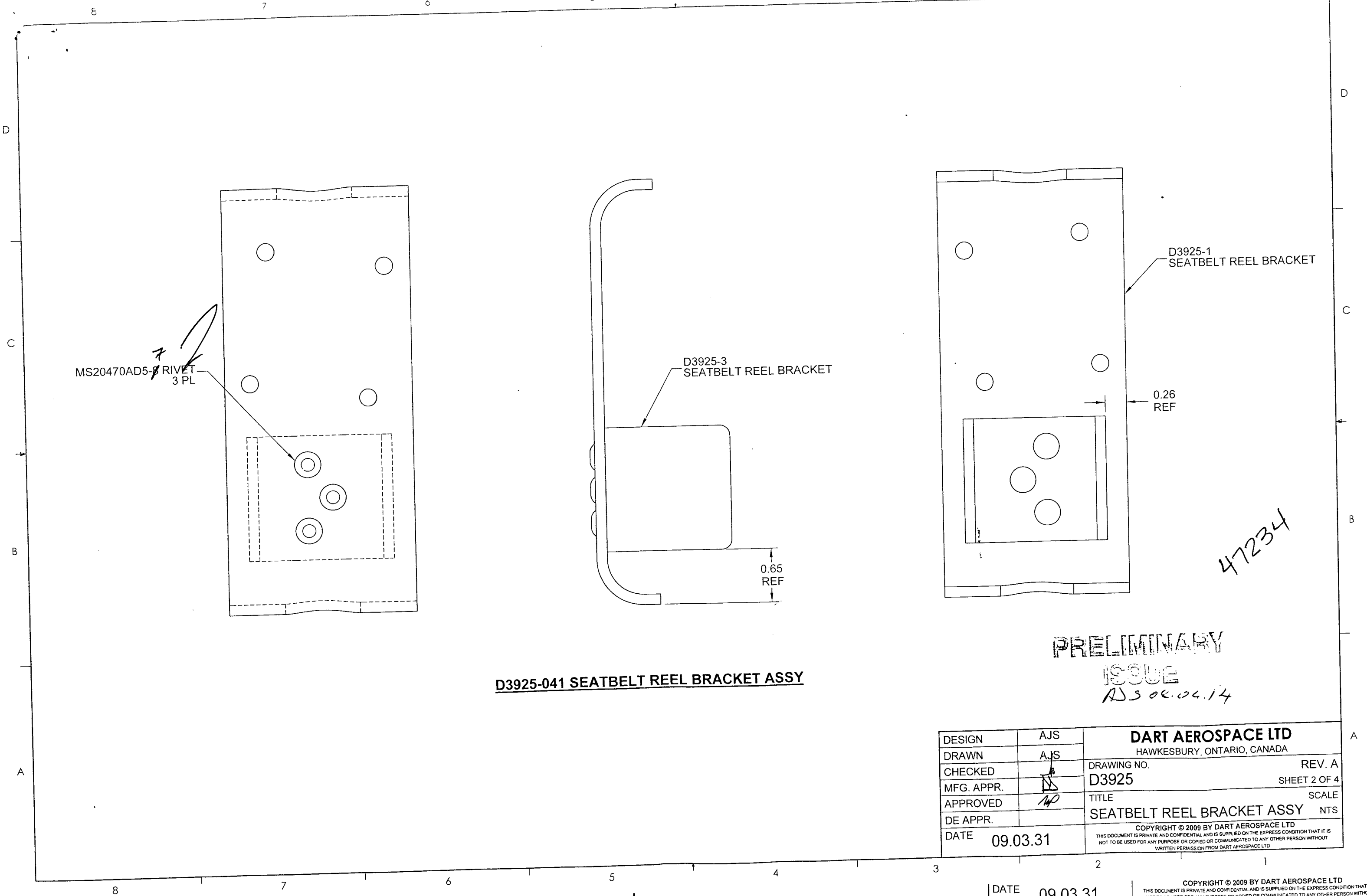


D3925-3F FLAT PATTERN

NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM 0.125 THICK PER AMS-QQ-A-250/11 OR AMS 4025/4027
REF DART SPEC M6061T6S.125
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.07 lbs

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CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D3925	SHEET 4 OF 4
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MS20470AD5-8 RIVET
3 PL

D3925-3
SEATBELT REEL BRACKET

D3925-1
SEATBELT REEL BRACKET

0.26
REF

0.65
REF

D3925-041 SEATBELT REEL BRACKET ASSY

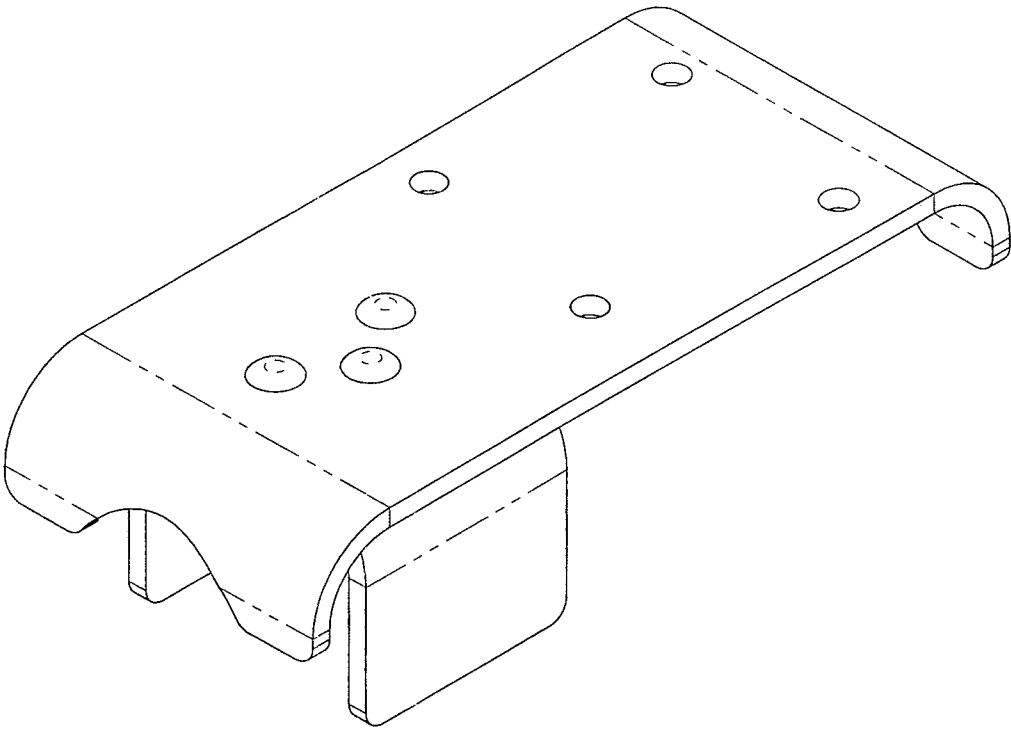
**PRELIMINARY
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AS 06.04.14

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QTY. -041	PART NUMBER	DESCRIPTION
1	X	D3925-041
9	1	D3925-1
10	1	D3925-3
21	3	MS20470AD5-8
		RIVET



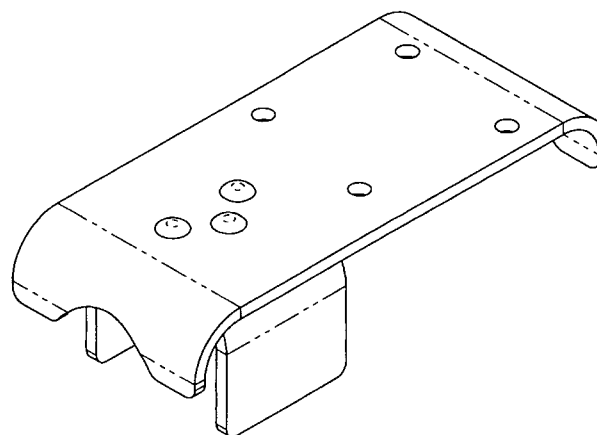
D3925-041 SEATBELT REEL BRACKET ASSY

PRELIMINARY
ISSUE
AJS 08.22.14

- NOTES:
- 1) MATERIAL:
 - 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3925-041" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 0.23 lbs

A	NEW ISSUE	AJS	09.03.31
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D3925	SHEET 1 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.		SEATBELT REEL BRACKET ASSY	NTS
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ITEM NO	QTY. -041	PART NUMBER	DESCRIPTION
1	X	D3925-041	SEATBELT REEL BRACKET ASSY
9	1	D3925-1	BRACKET
10	1	D3925-3	BRACKET
21	3	MS20470AD5-8	RIVET



D3925-041 SEATBELT REEL BRACKET ASSY

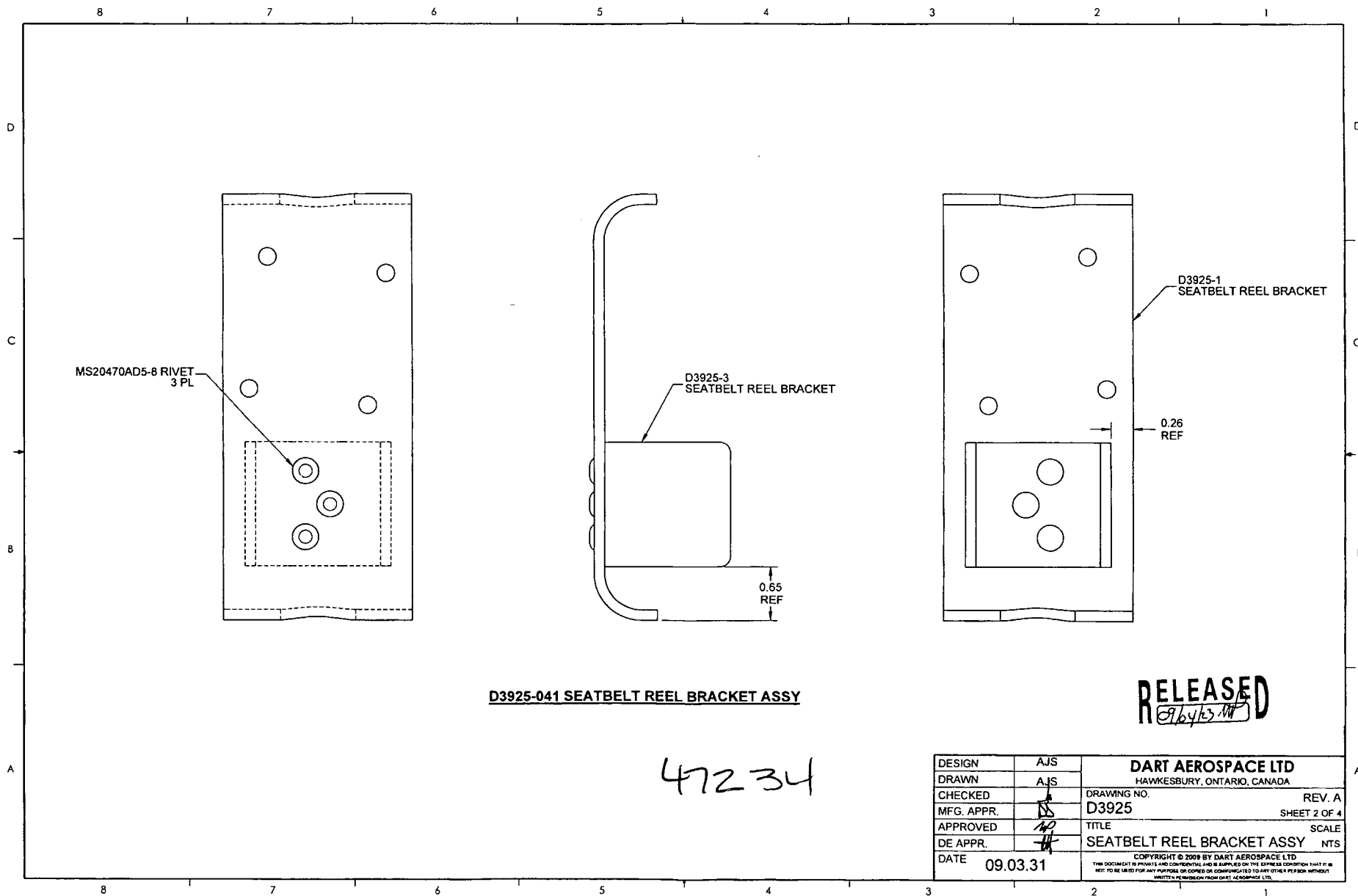
RELEASED
09/03/31

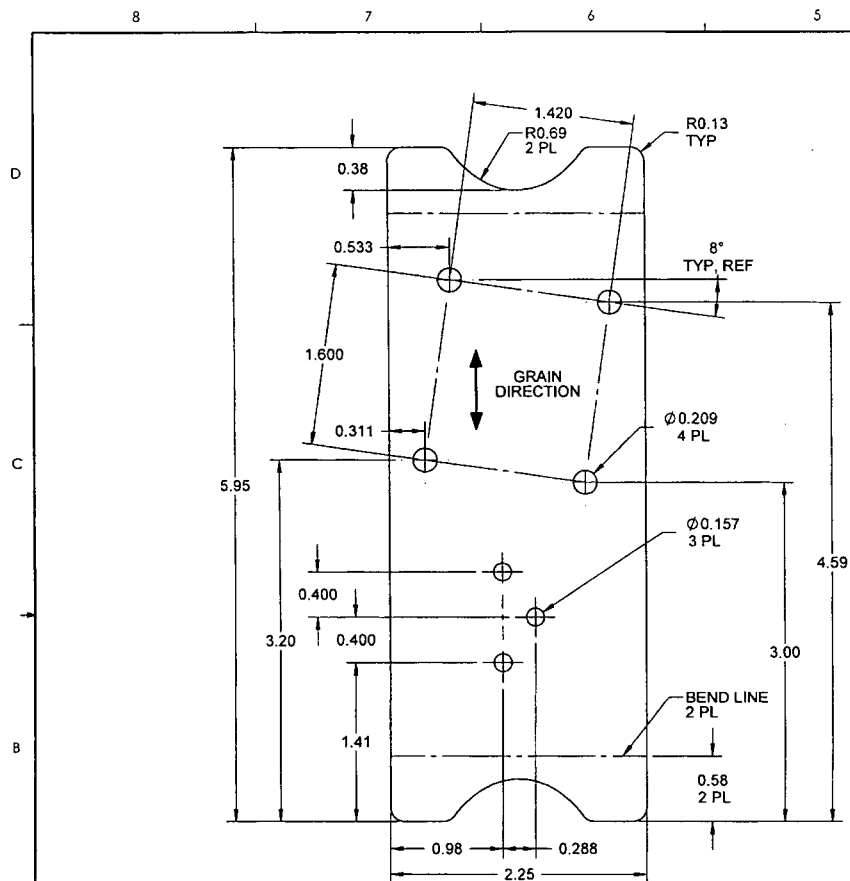
47234

NOTES:

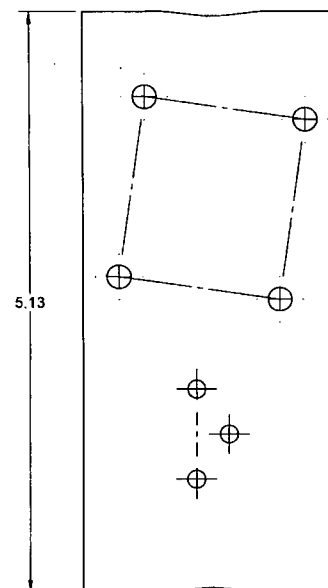
- 1) MATERIAL:
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3925-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.23 lbs

A	NEW ISSUE	AJS	09.03.31
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3925	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		SEATBELT REEL BRACKET ASSY	NTS
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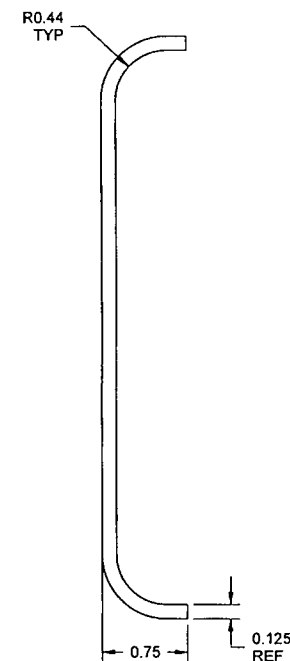




D3925-1F FLAT PATTERN



D3925-1 SEATBELT REEL BRACKET
(MAKE FROM D3925-1F)







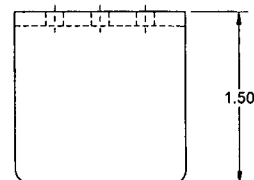
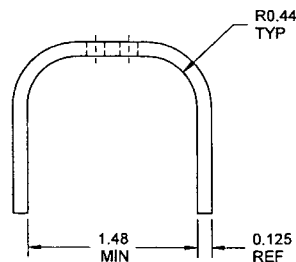
RELEASED
09/04/23

NOTES:

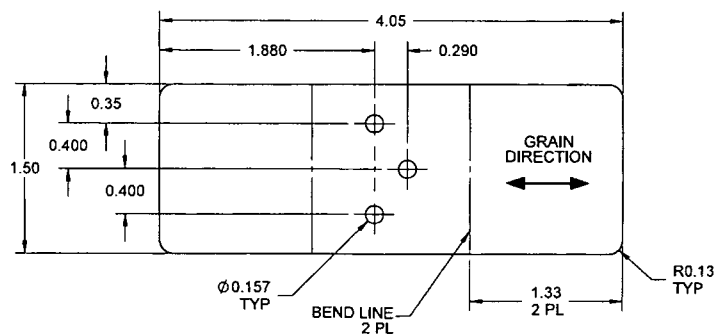
- 1) MATERIAL: 6061-T6 ALUMINUM 0.125 THICK PER AMS-QQ-A-250/11 OR AMS 4025/4027
REF DART SPEC M6061T6S.125
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.15 lbs

47234

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3925	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		SEATBELT REEL BRACKET ASSY	NTS
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D3925-3 SEATBELT REEL BRACKET
(MAKE FROM D3925-3F)







D3925-3F FLAT PATTERN

NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM 0.125 THICK PER AMS-QQ-A-250/11 OR AMS 4025/4027
REF DART SPEC M6061T6S.125
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.07 lbs

47234

RELEASED
9/6/23 MTD

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3925	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		SEATBELT REEL BRACKET ASSY NTS	
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